

**Work Order ID 53405**

November 03, 2009 3:46:52 PM



Page 1

Item ID: D2989-041

Accept



Setup Start



Revision ID: D

Item Name: Basket Lid Assembly

Stop



Start Date: 11/4/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: U

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2989	Rev D

100



Large Fab

0.00

Large Fab



Memo

0.00

Large Fab

B

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

1.5 ensure one D3836-041 has no bushings and has holes per DS19473,

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig

\*\*\*\*cut cutouts with zip cut as per dwg D3832\*\*\*\*

3- remove from jig and weld lable plate as per dwg D2989

A/R ER316 S.S. Rod Batch: M109213

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 53405**

November 03, 2009 3:46:52 PM



Page 2

Item ID: D2989-041

Revision ID: D

Item Name: Basket Lid Assembly

Start Date: 11/4/2009 Start Qty: 1.00

Accept



Setup Start



Stop



Required Date: 11/11/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Set Up/  
Run Hours

0.00

Draw  
Number

10071106

Draw  
Rev.Plan  
CodeAccept  
Qty

100

Reject  
Qty

0

Reject  
NumberInsp.  
Stamp

130



Powdercoat

Powder Coating

X pressure wash

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

11/12/10

Memo

0.00

⇒ 10071106

0.00

100

0

0

0

0

Memo

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg  
D2989

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

10:45AM

400°F

11:15AM

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:30AM

400°F

12:00PM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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November 03, 2009 3:46:52 PM



Page 3

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Revision ID: D

Item Name: Basket Lid Assembly

Start Date: 11/4/2009 Start Qty: 1.00

Required Date: 11/11/2009 Req'd Qty: 1.00

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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131	Wing Walk as per dwg QSI005 4.4 Batch: <i>1112623</i>	0.00	<i>BL 09-11-10</i>	<i>①</i>					
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HandFinish

Hand Finishing

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

Mask lid prior to spray paint black and wing walk as per dwg  
A/R Spray paint black batch: *1112737*

141



Packaging

Packaging

Identify as per dwg & Stock Location: *W/O S3399*

0.00

Memo

0.00

*J.S. 11-11*
*J.S. 11-11*

W/O:		WORK ORDER CHANGES					
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November 03, 2009 3:46:52 PM



Page 4

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Required Date: 11/11/2009 Req'd Qty: 1.00



Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**

150



QC

Quality Control

**Operation  
Description**

QC21- Final Inspection - Work Order Release

**Set Up/  
Run Hours**

0.00

**Draw  
Number**
**Draw  
Rev.**
**Plan  
Code**
**Accept  
Qty**
**Reject  
Qty**
**Reject  
Number**
**Insp.  
Stamp**

Memo

0.00

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Page 1

November 03, 2009 3:46:52 PM

Work Order ID: 53405



6

Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 11/4/2009

Required Date: 11/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH 		Manufactured	No			100	Each	23.0000	2.0000			

Rib

**Warehouse****Location**

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

22

51872

10

53213

12

PD 09.11.04

D2506RevF



Manufactured

No

100

Each

11.0000

1.0000



Label Plate

**Warehouse****Location**

Main Warehouse

ST

1

44275

1

Main Warehouse

WA

10

52834

10

PD 09.11.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 2

November 03, 2009 3:46:52 PM

Work Order ID: 53405



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 11/4/2009

Required Date: 11/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2512-7RevE		Manufactured	No			100	Each	4.0000	1.0000			

Rib

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

4

48666

100

4

Each

56.0000 2.0000

PD 09.11.04

D2581RevA1



Manufactured

No

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

12

46086

2

48428

1

51120

9

Main Warehouse

WA

44

50872

1

51745

43

PD 09.11.05

Mounting Bracket

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 3

November 03, 2009 3:46:52 PM

Work Order ID: 53405



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 11/4/2009

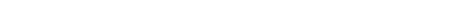
Required Date: 11/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2989-13RevD		Manufactured		No		100	Each	4.0000	2.0000			



Rib

WarehouseLocation

Main Warehouse

WA

Loc QtyLoc Code

4

51864

PD 09.11.04

D2989-19RevD



Manufactured

No

100

Each

9.0000 2.0000



Rib

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

1

44867

PD 09.11.04

Main Warehouse

WA

1

51338

\_\_\_\_\_

51874

8

4

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

Page 4

November 03, 2009 3:46:52 PM

Work Order ID: 53405



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 11/4/2009

Required Date: 11/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3832-3RevA		Manufactured	No			100	Each	4.0000	1.0000			

Mesh (Lid)

WarehouseLocation

Main Warehouse

ST	4	
48608	1	
51865	3	

PD 09.11.05

D3833-3RevA



Manufactured

No

100

Each

15.0000 2.0000

Mesh (Lid End)

WarehouseLocation

Main Warehouse

ST	15	
46308	3	
53136	12	

PD 09.11.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 5

November 03, 2009 3:46:52 PM

Work Order ID: 53405



Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 11/4/2009

Required Date: 11/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3836-041RevA		Manufactured	No			100	Each	4.0000	1.0000			

Rib Assembly (Basket Lid, LH)

WarehouseLocation

Main Warehouse

ST

Loc Qty

2

51336

Loc Code

PD 09.11.04

Main Warehouse

WA

2

53129

2

D3836-042RevA



Manufactured

No

100

Each

4.0000

1.0000



Rib Assembly (Basket Lid, RH)

WarehouseLocation

Main Warehouse

ST

Loc Qty

2

51337

Loc Code 

Main Warehouse

WA

2

53130

2

53436 PD 09.11.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 6

November 03, 2009 3:46:52 PM

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Parent Item: D2989-041RevD



Parent Item Name: Basket Lid Assembly

Start Date: 11/4/2009

Required Date: 11/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3852-041RevA		Manufactured	No			100	Each	4.0000	1.0000			

Rib Assembly

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

51333

4

53127

2

53127

2

PD 09.11.04

D3852-042RevA

Manufactured

No

100

Each

4.0000 1.0000

Rib Assembly

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

51332

4

53126

2

53126

2

PD 09.11.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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8

7

6

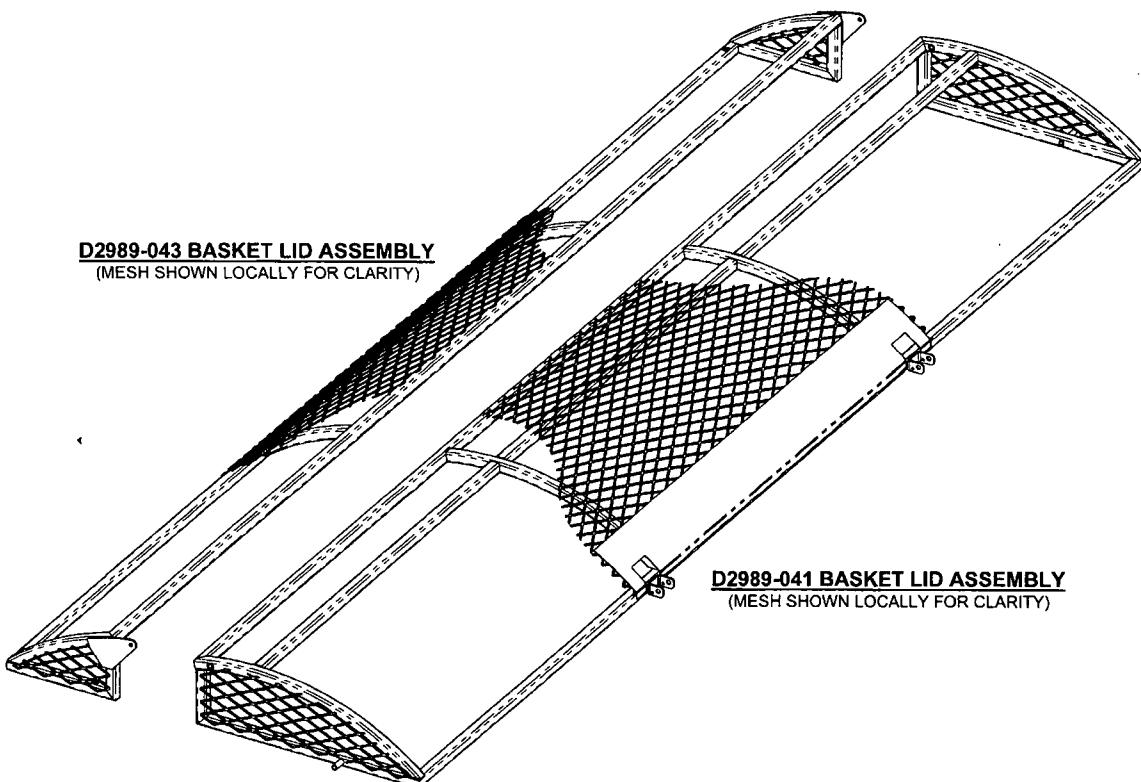
5

4

3

2

1



ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

#52405

RELEASED  
08/11/18 MM

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9-12; D3836-042 REPLACES D2989-11; D3838-041 REPLACES D2989-1-7; D3838-042 REPLACES D2989-7; D2989-2 REMOVED; D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9-10 (NOW ON D3836 DWG), D2989-1/2-7/15 (NOW ON D3836 DWG) AND D2989-11-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM		
	MB	08.09.24	
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD		
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS		
A	NEW ISSUE		
REV.	DS	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKSLEY, ONTARIO, CANADA	
CHECKED	RAS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY INFORMATION AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISCLOSED TO OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8      7      6      5      4      3      2      1

8      7      6      5      4      3      2      1

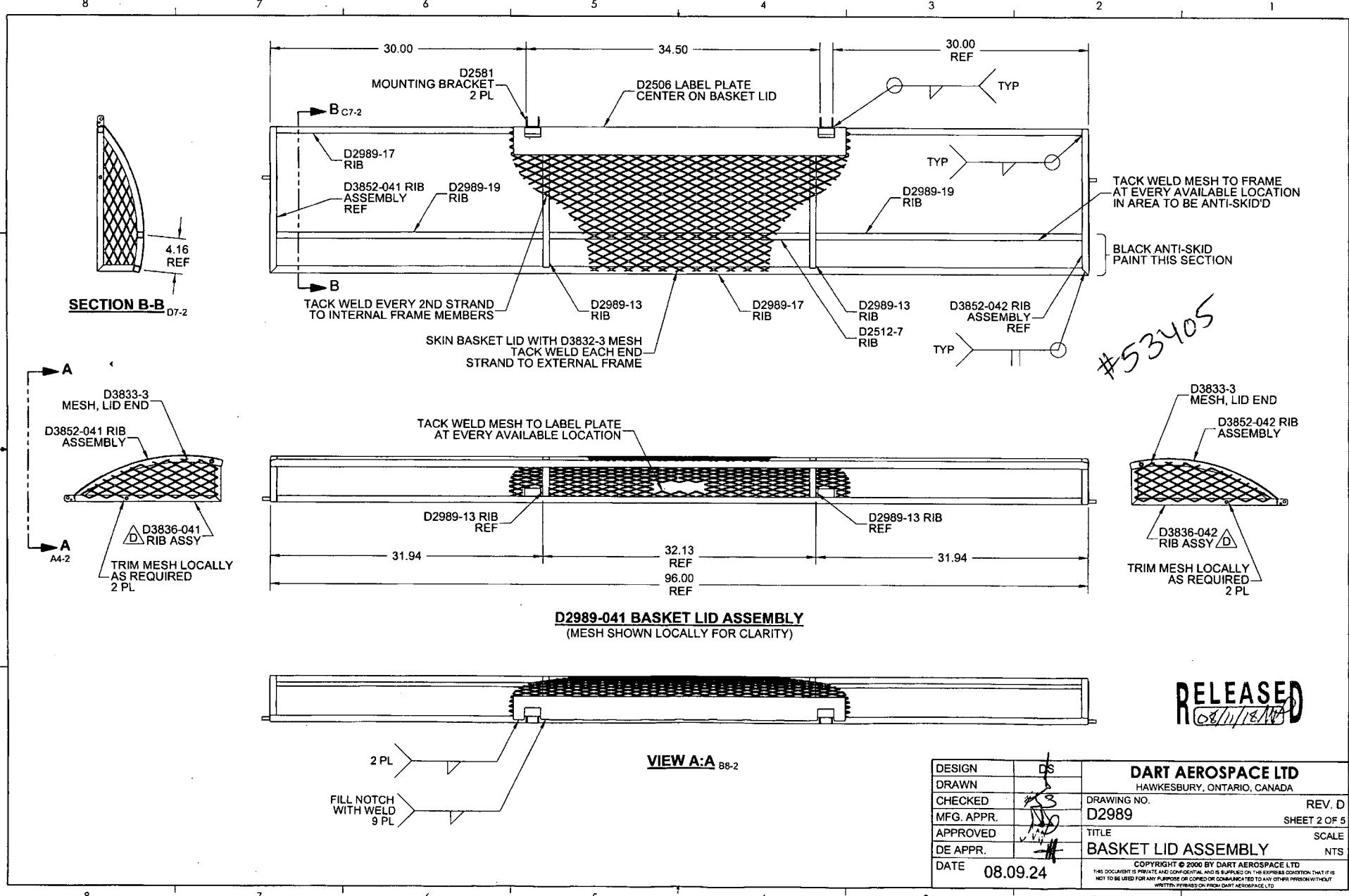
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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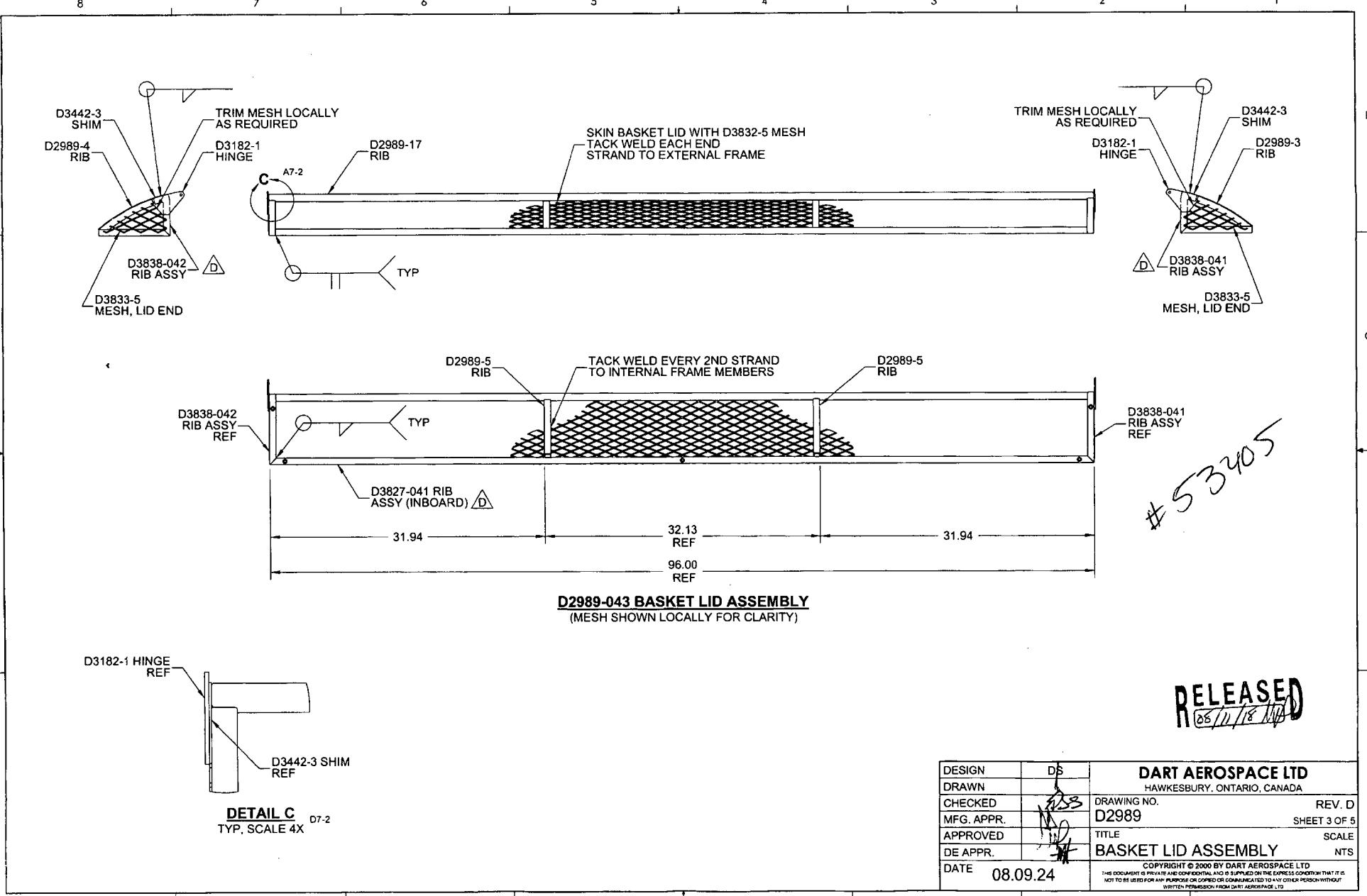


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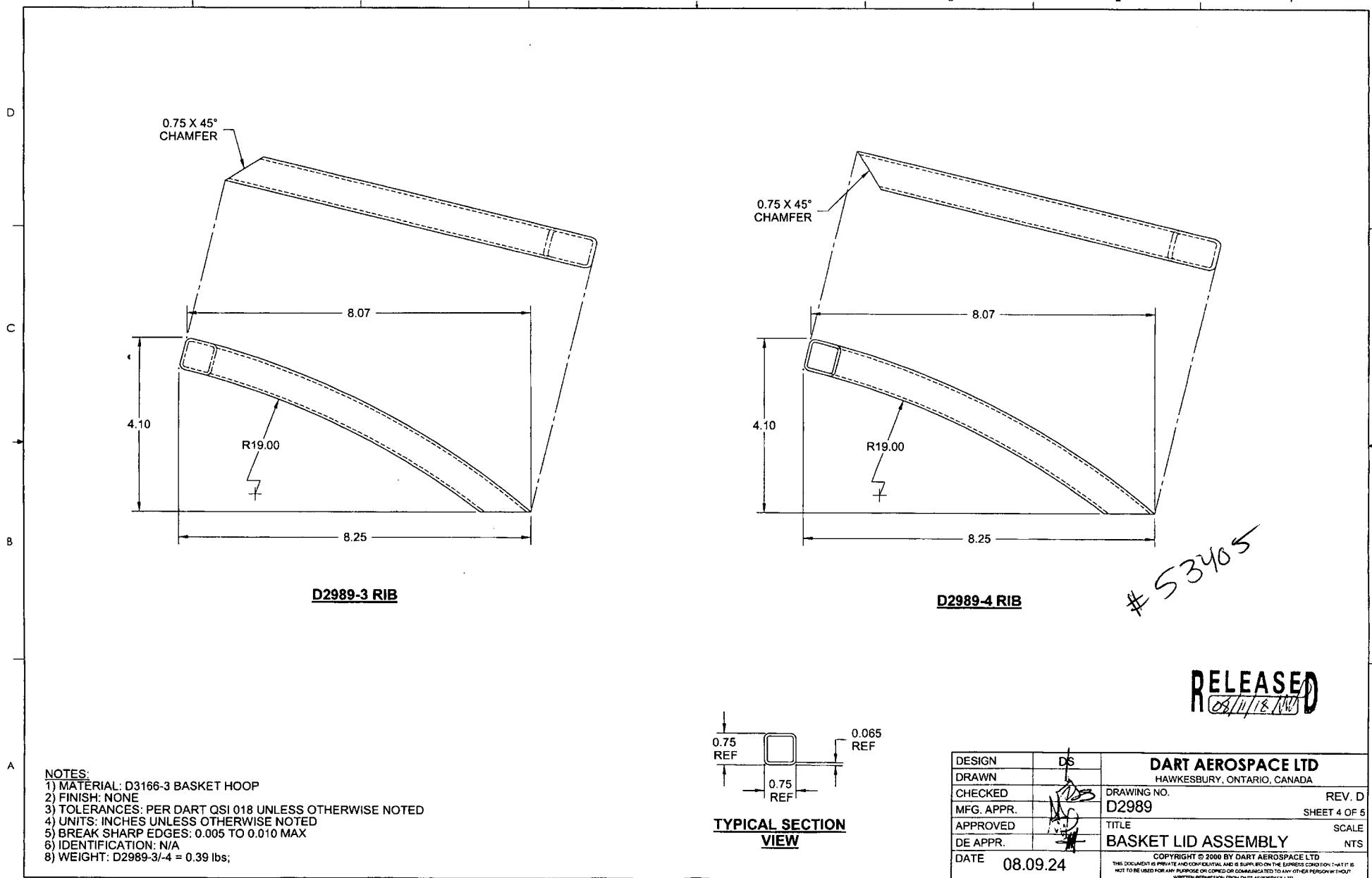
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

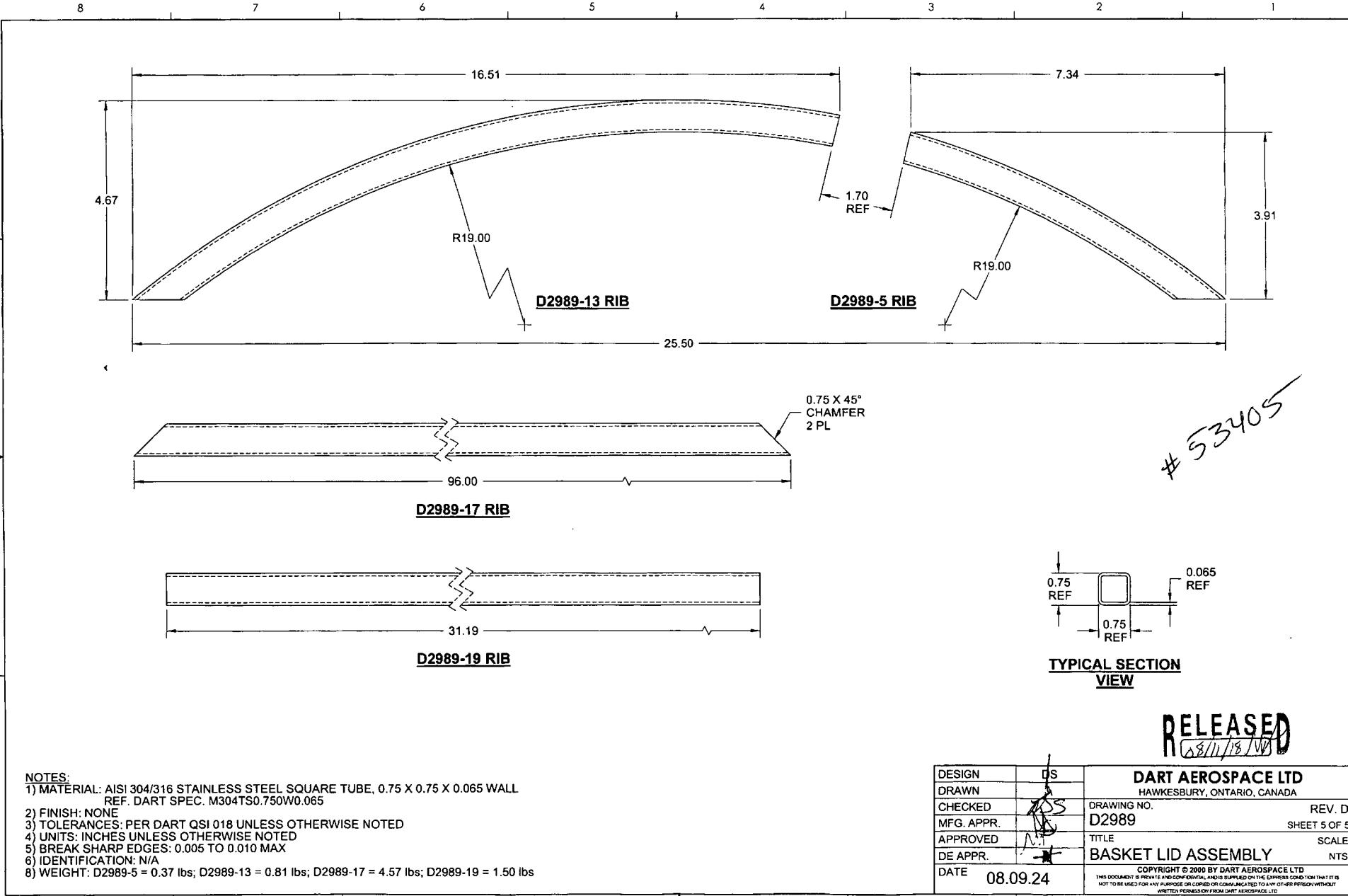
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries